Work Order ID 112742 Page 1 February-06-14 10:50:05 AM Item ID: D3622-1 Accept *N900040100* Setup Start **Revision ID: Item Name:** Ball Stud *40* **Start Date:** 2/06/14 **Start Oty: 40.00 Cust Item ID:** Required Date: 2/20/14 Req'd Qty: 40.00 **Customer:** Reference: Run Process Plan: ML5 Date: 14-02-06 Tooling: Approvals: Date: Stop QC: _____ Date: ____ SPC (Y/N): Date: Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Accept Reject Reject Insp. Work Center ID Description Run Hours Code Qty Qty Number Stamp **Draw Nbr Revision Nbr** D3622 Rev C 100 0.00 Hardinge CNC LATHE SMALL 40 8 *100* Hardinge 0.00 Memo Hardinge CNC Lathe Small Fil 14/02/07 1-TURN AS PER FOLIO FA686 & DWG D3622. FOLIO REV: C 2-DEBURR AS REQUIRED 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* 40 0 F& 14/02/07 QC 0.00 Memo **Quality Control**

0.00

on 14/02/11

40 8

120 OC

Memo

Quality Control

120

QC8- Inspect parts - second check

0.00

		ι Λ											
DQA:	Q	ASK.	Date:	14/21	128								
QA Closed:		10/	Date:	14-2	7-14	WORK ORDER NON	-C(ONFOF	RMANCE / UPDATE	Wo	ork Order up	odate only	AEROSPACE
Work Orde	er:	' 11' 11211			 ,	DISPOSITION			AGAIN	NST DE	PARTMENT	/PROCESS	
Part I	No.	D30	122-1			Rework Scrap Use-as-is Suspected Unapproved		Therm	Skid-tube Crosstu Machining Small I noforming Finish Large Fab Compos	Fab iing		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descr	iption of work order update		Initial	Action		Sign &		1
Cause		Date	Step	Qty	Desci	or non-conformance	1	nief Eng	Description		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	,	14.02.11	(00	260	12 PC. 1	H A' 15. 0.145 LIEU OF 0.125. 10 CORPECT FULL PROOF		14.02.11	ACCOPTABLE THE PRATCH ONLY. NOT AFFECTIVE STACK UP ON NOT PACK. CREAT chilling hould be usen through length throw spacin / Ref	•		ort 14loshi Jul.	DAS 16 9-89
Landi	nø (iear .		<u></u>		General	FA	ULT CAT	EGORY			, ,	
Landi		Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspection Marks/Ch	t Strip in atter equence	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Instructi Misalig Mislabe Misread Off-set Out of C	re on Incomplete/Unqualified ons Incomplete/Unclear ned/off center led	+	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
		Wave/Twi	ist in Tub	e		Fit/Function	1	Out of S	equence				

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Work Ord February-06-14				*112	742*						Page 2
Item ID: Revision ID: Item Name:	D3622-1 Ball Stud			Accept	*N900	040	100)* Se	etup Sta	I W	S1* S2*
Start Date: Required Date Reference:	2/06/14 : 2/20/14	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item I	D:					
Approvals:	Process Pla	n:	Date:	Tooling:	Da	ite:	-	R	un Sta	rt *N	R1*
,	QC: , ,,		Date:	SPC (Y/N):	Da	ite:			Sto	^{op} *N	R2*
Sequence ID/ Work Center I	D	Operation Description Identify as per dwg & Stor	ck Location: <u>57658</u>	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty DAS	Reject Number	Insp. Stamp
120 Packaging Packaging		Memo		0.00				40x	28 - 9-89	14-02:	-1/
140		QC21- Final Inspection -	Work Order Release	0.00						_	
*14 0 *		Memo		0.00						10/1	1-02-12

Quality Control

M4-02-12

DQA:		_ Date:			•									
04 Classid		Data.			WORK ORDER NON	-C(ONFO	RMANCE / U	PDATE					AEROSPACE
QA Closed:		Date:					r			Wo	ork Order up	odate only		
Work Orde	er:				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
	,				Rework]		Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo.				Scrap	1		Machining	Small Fab	-	Pro	d. Eng. Coor.	⊢	Quality
					Use-as-is		Therr	noforming	Finishing			re/Packaging		Other
NCR N	10				Suspected Unapproved]		Large Fab	Composite			Supplier		
Root				Desci	ription of work order update		Initial	Act	tion		Sign &			1
Cause	Date	Step	Qty		or non-conformance	1	ief Eng		ription		Date	Verificatio	n	QC Inspector
Design										\neg		Vermoution		QC HISPECTOR
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator														
Offset/Setup														
Process														
Supplier														
Training										ı				
Transport														
Unapproved		<u> </u>												
						FA	ULT CAT	EGORY				-		
Landir	g Gear				General									
}	Bending				Bend		Folio/P	rogram			Outside Dim	ensions		Pressure/Forced
]	Centre N	ot Concer	ntric		BOM/Route		Grain				Over/Under	tolerance		Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorred	it		Temperature/Cure
1	Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	on Incomplete/Ur	nqualified		Part Lost/Mi	ssing		Weld
	Cuffs				Contamination		Instruct	ions Incomplete/U	Jnclear		Part Moved			Wrong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center			Positioned W	/rong		•
]	Heat Trea	at			Cut Too Short		Mislabe	eled			Power Loss/	Surge		Other
]	Inspectio	n Strip in	Tube		Drawing		Misread	1	·			'		
	Marks/Cl	natter			Drill Holes		Off-set			•				
ļ	Turning S	Sequence			Finish		Out of (Calibration		•			-	
	Wave/Tw	vist in Tub	e		Fit/Function		Out of S	Sequence		•				

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Picklist Print

February-06-14 10:50:11 AM

Work Order ID: 112742

112742

Parent Item:

D3622-1

D3622-1

Parent Item Name: Ball Stud

Start Date: 2/06/14

Required Date: 2/20/14

Page 1

Start Oty: 40.00

Required Oty: 40.00

Comments:

IPP Rev:A New Issue 07-04-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303H0.500		Purchased	No	,		100	f	12.0000	0.108	5			
N/303H0	500								**				

M303H0 500

303 HEX BAR .500

Location Loc Qty Loc Code MAT018 12 12 m127464

th-14/02/07

DQA:		. Date:			- WORK ORDER NON		ONICO	D24421CE / L	IDD ATE			*	TRAC
QA Closed:		Date:			WORK ORDER NON	1-C(JNFO	RIVIAINCE / C		Work Order u	pdate only		AEROSPACE
Work Order:				•	DISPOSITION				AGAINST I	DEPARTMENT	/PROCESS		
Part No. NCR No.					Rework Scrap Use-as-is Suspected Unapproved		ł	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	- -i	Water Jet od. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root				Desc	ription of work order update		Initial	Ac	ction	Sign &			
Cause	Date	Step	Qty		or non-conformance	Ct	nief Eng	Desc	cription	Date	Verificatio	n	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved									·				
l andina						FA	ULT CA	TEGORY					
Landing	Gear Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspectio Marks/Ch	nk/Ripple at n Strip in natter	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Utions Incomplete/ gned/off center eled d	/Unclear	Outside Dim Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	tolerance ct issing Vrong	SS T V V	Pressure/Forced Get-up Temperature/Cure Weld Wrong Stock Pulled Other
] Wave/Tw	ist in Tub	ne		Fit/Function		Out of	Saguanca					

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DART AEROSPACE LTD	Work Order:	112445
Description: Ball Stud	Part Number:	D3622-1
Inspection Dwg: D3622 Rev: C		Page 1 of 1

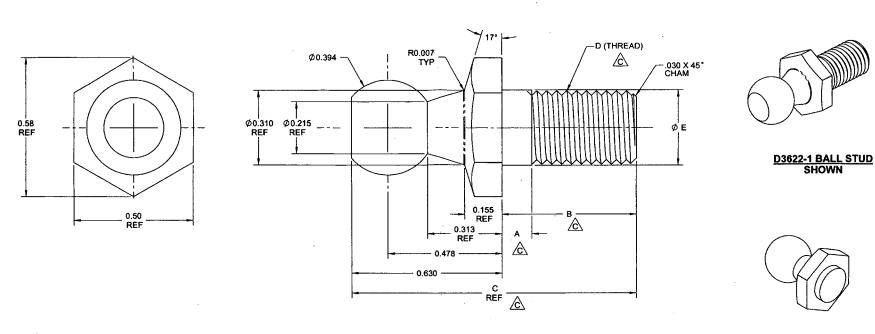
FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
	l e e e e e e e e e e e e e e e e e e e	 2

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.58	+/-0.030	,570	7		FK-04	Vern.
0.50	+/-0.030	.500			11	9
Ø0.394	+/-0.010	,3945	7		h	fy ·
Ø0.310	+/-0.010	.310	>		K	4
Ø0.215	+/-0.010	.ZIS	7		1,	4
0.155	+/-0.010	۰۱5 5	7		4	h
0.313	+/-0.010	. 31 3	7		h	٩
0.478	+/-0.010	8FH°	7		4	\
0.630	+/-0.010	,630	7		h	И
0.125	+/-0.010	125	7		h	A
0.563	+/-0.010	.562	7		4	h
1.19	+/-0.030	1.192	7		٨	h
0.3125-24UNF-3A	+0.000/-0.072	2115	/		FX-09	Mic.
M.O.W.	Min = 0.3336 Max = 0.3363	.3354	7		1.	l,
*						
					,	

Measured by:	FA	Audited by:	and	Preliminary Approval:	
Date:	14/02/07	Date:	14/02/12	Date:	

Rev	Date	Change	Revised by	Approved
Α	08.04.15	New Issue	KJ/DD	
В	10.02.02	Dwg Rev updated	KJ 10	- \\
С	11.02.18	Dimensions updated per Dwg Rev C	KJ 9K)	<u> </u>



SHOP COPY **RETURN TO** ENGINEERING **UNCONTROLLED COPY** SUBJECT TO AMENDMENT

С

WITHOUT NOTICE

WORK GRIDER NO. 112742 MCJ 140206

PART DIM DIM WEIGHT THREAD NUMBER MIN MAX (LBS) D 0.3053 0.3125 D3622-1 0.125 0.563 1.19 0.3125-24UNF-3A 0.03 D3622-3 0.125 0.563 1.19 0.1875-32UNF-3A 0.1840 0.1900 0.03 0.3125-24UNF-3A D3622-5 0.090 0.900 1.53 0.04 0.3053 0.3125 0.3125-24UNF-3A 0.3053 0.3125 0.060 0.330 0.96 0.03 D3622-7 0.3125-24UNF-3A 0.3053 0.3125 D3622-9 0.090 1.160 1.79 0.04 D3622-11 0.060 N/A 0.69 0.02 NOT THREADED 0.270 0.300 D3622-13 0.090 0.680 0.3125-24UNF-3A 0.3053 0.3125 1.31 0.03

D3622-X BALL STUD



D3622-11 BALL STUD

SHOWN

c	SHEET:	1: ADD -5, -7 2 DELETED	, -9, -11 & -13. ADD D3622-X TABLE.	JPH	10.07.20			
В	ADD -3	(SHEET 2)		HS	09.09.18			
Α	NEW IS	SUE	-	МВ	07.04.13			
REV.			DESCRIPTION	BY	DATE			
DESIG	N	JPH	DART AEROS	PACE L	TD			
DRAW	N	JPH		HAWKESBURY, ONTARIO, CANADA				
CHECK	ŒD	A	DRAWING NO.		REV. C			
MFG. A	PPR.	(A)	// D3622		SHEET 1 OF 1			
APPRO	VED	MAP	TITLE		SCALE			
DE API	DE APPR.		☐ BALL STUD	LL STUD N				
DATE	10.0	7.20	COPYRIGHT © 2009 BY DA THIS DOCUMENT IS PROVIDE AND CONFEDERAL AND IS IN	UPT LED ON THE EXPRES	S CONDITION THAT IT IS			

NOTES: 1) MATERIAL: AISI 303 HEX BAR REF DART SPEC M303H0.500

2) FINISH: WE SEE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.00 TO 0.010 MAX 6) IDENTIFICATION: IDENT P/N D3622-X & B/N PER QSI 044

6) IDENTIFICATION, IDENTIFICAT

D